Work Orde Friday, August 2												Page 1
Revision ID:	D3240-1 Frame			Accept				S	Setup	Start Stop		
	8/26/2011 9/9/2011	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item I Customer:	D:					118811181	
Approvals:	Process Plan		Date: Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										100
D3240	Rev	В										
Waterjet FLOW CNC Waterje حکام در	et	FLOW WATER JET Memo 1-Cut as per Deburr if ne	r Dwg D3240 □Dwg Rev:	0.00 0.00 <u>\$</u> _□Prog Rev:_	<u>R</u> = 2-			HB	(<u>~ 8</u> .	-31	4	
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				,	5			
QC Quality Control		Memo		0.00				<u> </u>	- <u>8</u> -	31	-	. ——

120 QC

QC8- Inspect parts - second check

0.00 Sulos 131

Quality Control

Memo

	•									
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-··- <u>-</u> ,			
							•			
							ىق ئۇلغ ئ			
Part No		PAR #:	Fault Categ	Fault Category:				\:	Date: _	
	R	esolution:	Disposition	:	_ QA: N/	C Clos	sed:		Date: _	-1
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Section			Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	1	oate	Section	on C	Chief Eng	QC Inspector
									·	
			,							
	:									
1	1	1	1 1		i i				i .	1

Work Order ID 73223

Page 2

Friday, August 26, 2011 10:26:46 AM D3240-1 Accept Setup Start Item ID: **Revision ID:** Stop Item Name: Frame 8/26/2011 Start Qty: 4.00 **Start Date: Cust Item ID:** Required Date: 9/9/2011 Req'd Qty: 4.00 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Date: **Approvals:** Stop SPC (Y/N): QC: Date: Date: Sequence ID/ Reject Reject Operation Set Up/ Tool ID Tool # Plan Accept Insp. **Work Center ID** Description Code Qty Qty Number Stamp **Run Hours** 0.00 130 Small Fab 0.00 Small Fab Memo Small Fab Deburr if necessary Chemical Conversion Coat per QSI005 4.1 140 0.00 4. Bl 11-8-31. HandFinish 0.00 Memo Hand Finishing QC3- Inspect Part Finish 0.00 150 0.00 Memo Quality Control

W/O:			WC	ORK ORDER CHANGE	= 5				
DATE	STEP	PRO			By	Date	Qty	Approval Chief Eng /	Approval QC Inspector
								Prod Mgr	,
									
						·			
Part No	:	PAR #: Fault Category: NCR: Yes No DQA: Date: Date: WORK ORDER NON-CONFORMANCE (NCR)							
								•	
NCR:							<u>-</u>		
		Corrective Action			on B				
DATE	STEP	Description of NC Section A	Initial Action Description		Sign	& Secti			QC Inspector
				***			20.01		

Work Order ID 73223

Friday, August 26, 2011 10:26:46 AM



Page 3

Item ID:

D3240-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Frame

8/26/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start Stop

Sequence ID/

Required Date: 9/9/2011

QC:

Date:

SPC (Y/N):

Set Up/

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Work Center ID 160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 37 217

Memo

Memo

Run Hours

0.00

0.00

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:								Date:	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		n B	Verifi	ication Approval		Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector

Picklist Print

Friday, August 26, 2011 10:26:44 AM

Work Order ID: 73223

Parent Item:

D3240-1

Parent Item Name: Frame



Start Date: 8/26/2011

Required Date: 9/9/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP B□05.04.28□Added Step 6 & 7□KJ/JLM□ IPP Rev C now water jet 07-11-01 DD

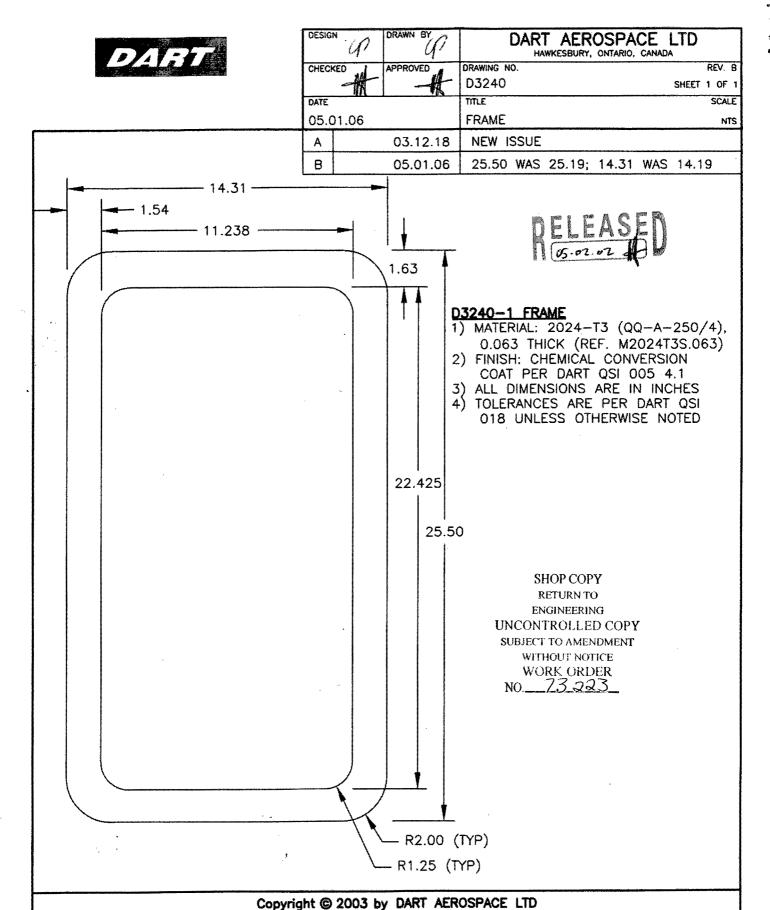
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	163.5000	2.534	10.66947 B(1	-8-31		
				Location MAT022		<u>Loc (</u>	<u>Qty</u> 63.5	Loc Code			(\(\tau \)	f	

163.5

117392

10349

Duit Aci	Copacc	Lia								
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										ī
		· 								
Part No:		PAR #:	Fault Ca	NCR: Y	Date:):				
Resolution:			Disposit	ion:	_ QA: N/C	Clos	ed:		Date: _	
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	Corrective Action S Initial Action Description		on B Sign &		Verification Section C		Approval Chief Eng	Approval QC inspector
		Section	Chief Eng	Chief Eng		ate	Jecli	OĮI O	Office Eng	QO INSPECTOR
				-						
		·					-			
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DART AEROSPACE LTD	Work Order:	<i>13</i> 223
Description: Frame	Part Number:	D3240-1
Inspection Dwg: D3240 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
25.50	+/-0.030	25.50	>		T 1BUI	
22.425	+/-0.010	20,428	×		+	
1.63	+/-0.030	1.634	>		U ALZ	
14.31	+/-0.030	14.31	a		7	
11.238	+/-0.010	11.238	>		7	
1.54	+/-0.030	1.543	5		V	
0.063	+/-0.010	, 064	>		ν	
**						

Date:	R 11-8-3	Date: 11.108/3/	Revised by	Approved
	140	Data: 11/2/21	Date:	N/A
Measured by:	FR	Audited by:	Prototype Approval:	N/A

Rev	Date	Change	Revised by	Approved
	07.11.23	New Issue	KJ/EC/DD	
			(5 /	V